

Date: Tuesday, 15/01/2008 12:34:28 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FUEL PURGE CANISTER		
Job Number	: 36777			Part Number	: D3262041		
Estimate Number	: 10440			Drawing Number	: D3262 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 15/01/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 31/01/2008 Qty:		
Previous Run	: 35990						
Written By	:						
Checked & Approved By	:						
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	36777A	FUEL PURGE CANISTER			Comment: Sub-Component FUEL PURGE CANISTER D3262-1 B <u>34242 A</u> <u>5P</u>	<u>BE 08/02/11</u>
2.0	36777B	FUEL PURGE CANISTER			Comment: Sub-Component FUEL PURGE CANISTER D3262-3 B <u>34242 B</u> <u>336777B</u> <u>10P</u>	<u>BE 08/02/11</u>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1			Comment: LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings	<u>m106390</u> <u>BE 08/02/11</u>
4.0	DO NOT USE	WELD INSPECTION			Comment: WELD INSPECTION Pressure test as per Dwg D3262	<u>QC#5 08/02/11 3/5 08/02/12 5</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<u>4/5 08/02/12 5</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107005



(5X)

Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

M. L 08/02/12

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(H.L)



(X5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-12

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 1CS113 (5)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/14

Job Completion



min 2008/2/13 (5)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

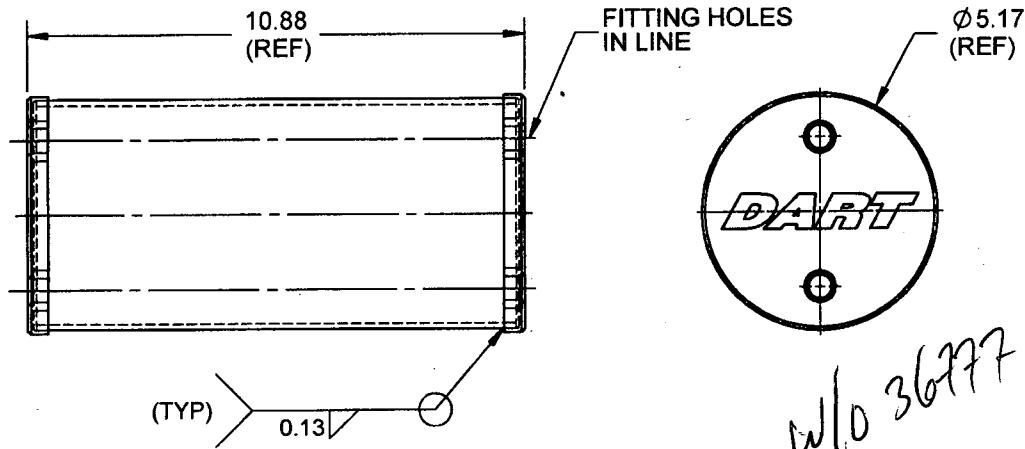
NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>HF</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4

REV	DATE	DESCRIPTION
A	04.05.06	FIRST ISSUE
B	05.02.14	ADD PRESSURE TESTING OPTION
C	06.08.31	Ø 5.165 WAS Ø 5.190

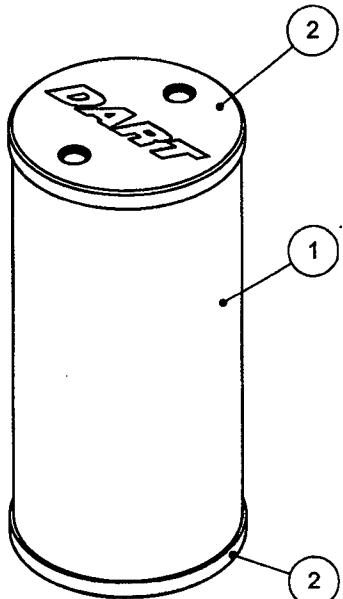
RELEASED

06.09.19 *HF***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO  CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>
CHECKED <i>PH</i>	APPROVED <i>MM</i>
DATE 06.08.31	DRAWING NO. D3262

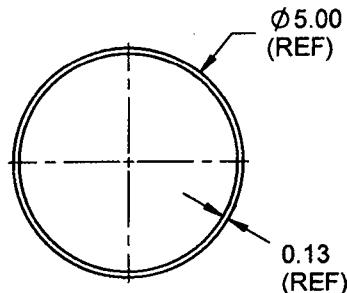
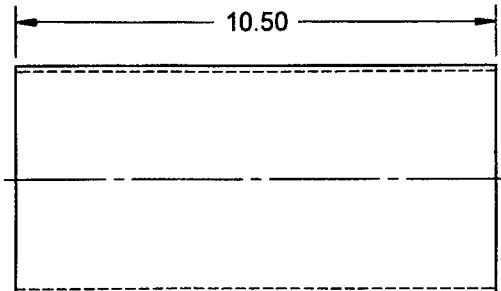
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 2

SCALE

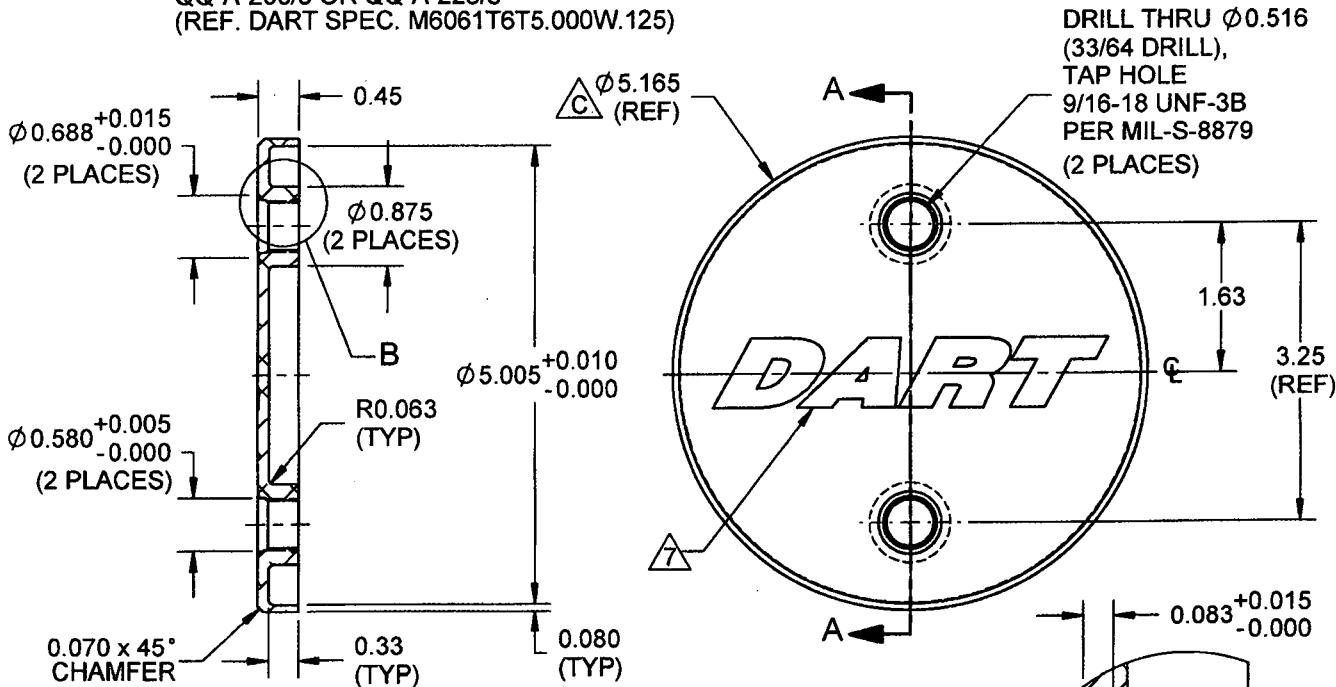
1:4

TITLE
FUEL PURGE CANISTERRELEASED
MM

06.09.09

D3262-1 TUBE

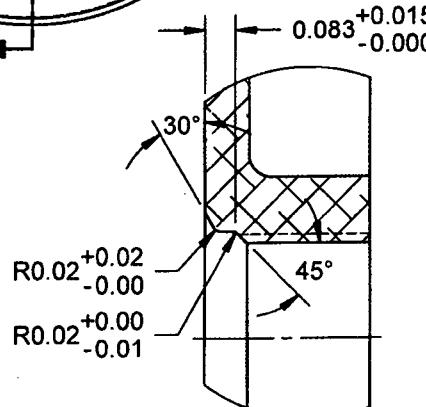
1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)


SECTION A-A
SCALE 1:2
D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)


DETAIL B
SCALE 2:1